

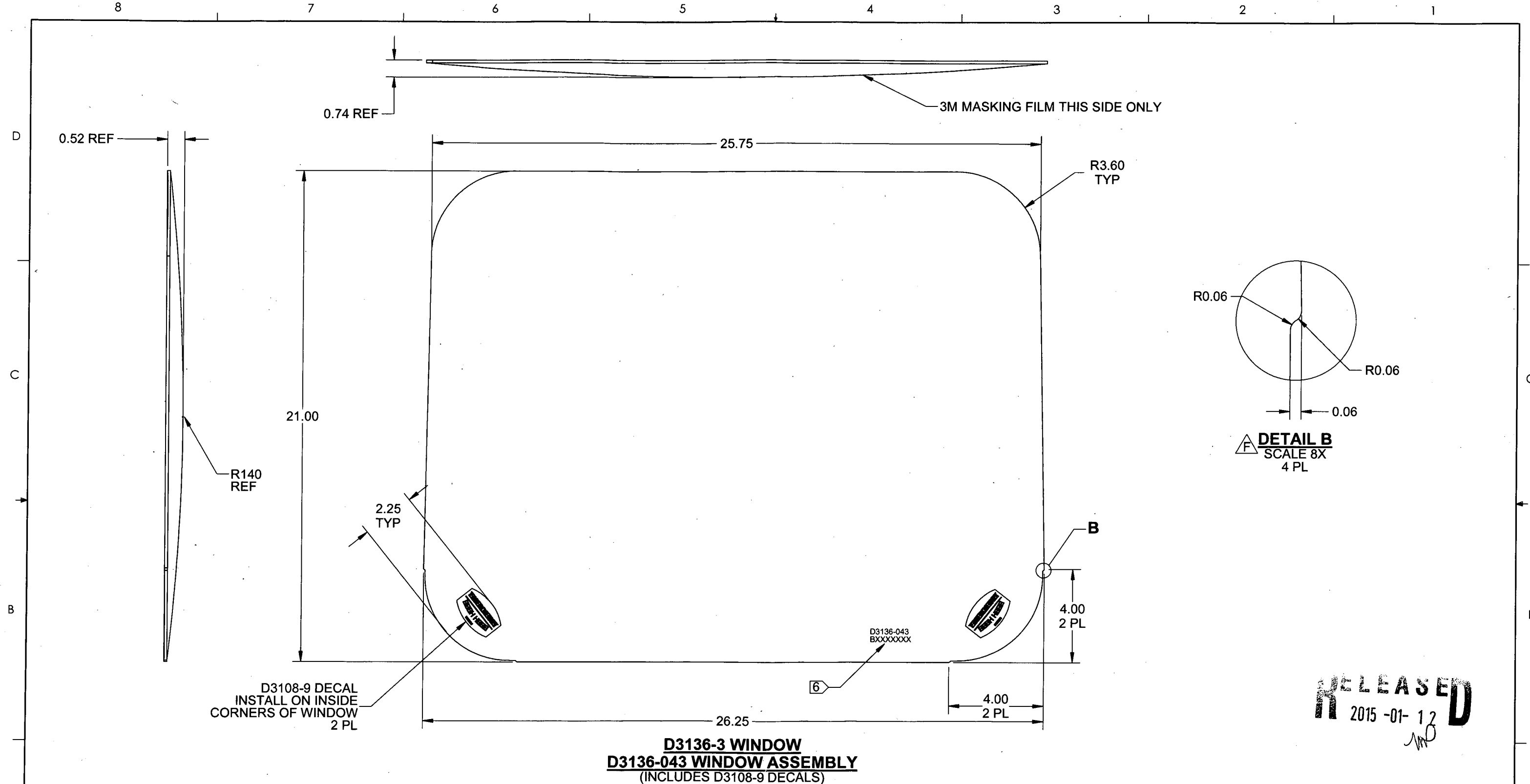
DETAIL A
SCALE 8X
4 PL

RELEASED
2015-01-12

**D3136-1 WINDOW
D3136-041 WINDOW ASSEMBLY
(INCLUDES D3108-9 DECALS)**

- NOTES:**
- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLASS G
CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK, (REF DART SPEC M-ACRYLIC-S.125)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3136-041" AND B/N PER DART QSI 044 6.4 (0.125" HIGH LETTERS/MAX DEPTH 0.005")
 - 7) WEIGHT: 3.3 +/- 0.25 lbs
 - 8) FORMING PROCESS: a) HEAT SHEET TO 250° F
b) DRAPE OVER D3136-T1 MOLD AND CLAMP
c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS

F	ADD D3136-5, D3136-045, DETAILS A/B/C, REVISE PART WEIGHTS	DB	14.12.10
E	REMOVE TRIM NOTE	DC	07.09.10
D	UPDATED MATERIAL NOTES	RF	05.12.01
C	ADDED FORMING AND ENGRAVING SPEC	KJ	04.05.05
B	ADDED D3136-3 AND D3136-043	RF	04.01.21
A	NEW ISSUE	DS	02.04.18
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3136	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SPACEDOOR WINDOW	NTS
DATE	14.12.10	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



RELEASED
2015-01-12

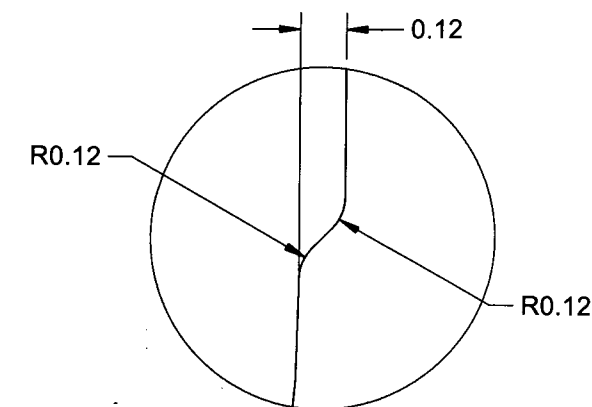
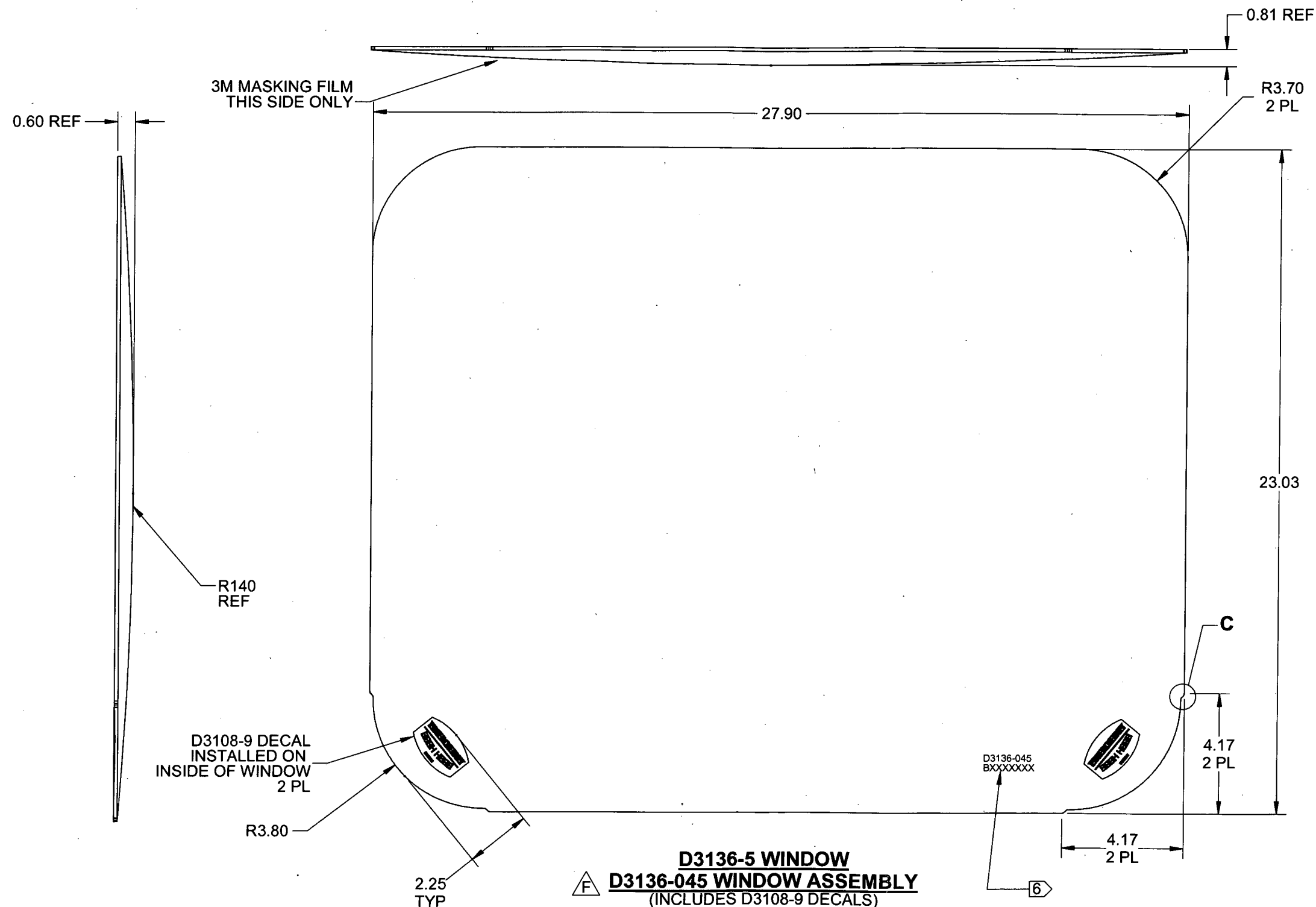
NOTES:

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- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3136-043" AND B/N PER DART QSI 044 6.4 (0.125" HIGH LETTERS/MAX DEPTH 0.005")
- 7) WEIGHT: 2.9 +/- 0.25 lbs
- 8) FORMING PROCESS: a) HEAT SHEET TO 250° F
b) DRAPE OVER D3136-T1 MOLD AND CLAMP
c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3136	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SPACEDOOR WINDOW	NTS
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D
C
B
A

D
C
B
A



DETAIL C
SCALE 8X
2 PL

D3136-5 WINDOW
D3136-045 WINDOW ASSEMBLY
(INCLUDES D3108-9 DECALS)

RELEASED
2015-01-12

- NOTES:**
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 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3136-045" AND B/N PER DART QSI 044 6.4 (0.125" HIGH LETTERS/MAX DEPTH 0.005")
 - 7) WEIGHT: 3.4 +/- 0.25 lbs
 - 8) FORMING PROCESS: a) HEAT SHEET TO 250° F
b) DRAPE OVER D3136-T1 MOLD AND CLAMP
c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3136	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SPACEDOOR WINDOW	NTS
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